

Date: Thursday, 9/14/2006 7:29:33 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR ADAPTER
Job Number : 28565
Estimate Number : 12133
P.O. Number : N/A Part Number : D3476043
This Issue : 9/14/2006 S.O. No. : N/A Drawing Number : D3476 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
Previous Run : 26994 Material : N/A
Due Date : 10/6/2006 Qty: 4 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 06-01-31 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34763 DOME



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part Number Description Batch

1 D3476-3 blower motor adapter B 27020

2.0 D34767 TUBE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number Description Batch

2 D3476-7 Tube B 28590

3.0 D34761 duct



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part Number Description Batch

1 D3476-1 Duct B 28873

4.0 NAS1031C3W Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Qty Part Number Description Batch

4 NAS-1031C3W Nutplate M 101144

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018

MF: 06/10/17

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 28565

Part Number: D3476043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/11

INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

Job 10-17 ①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

Job 10-17 1

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/17

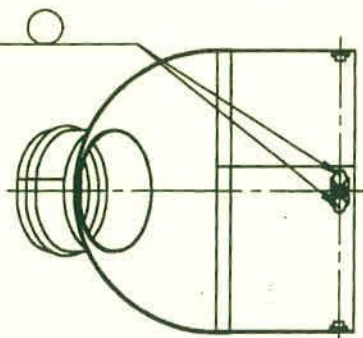
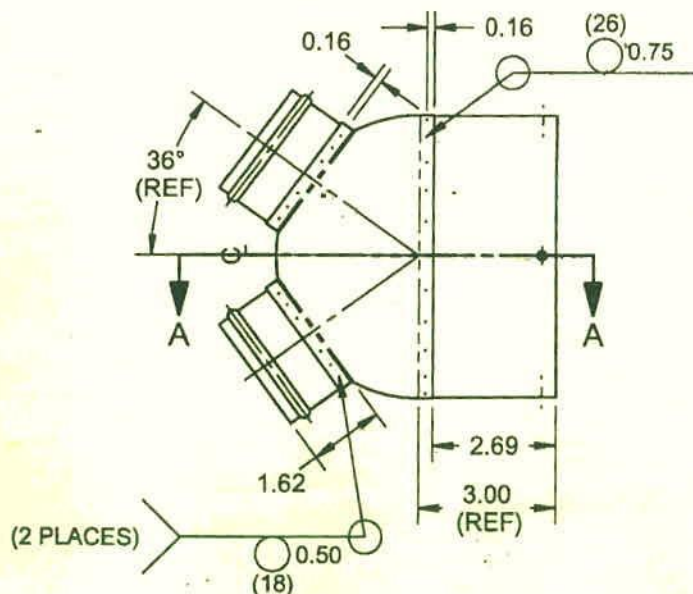
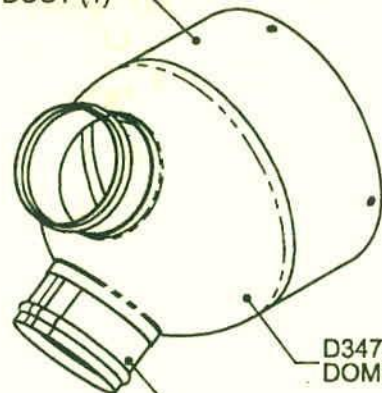
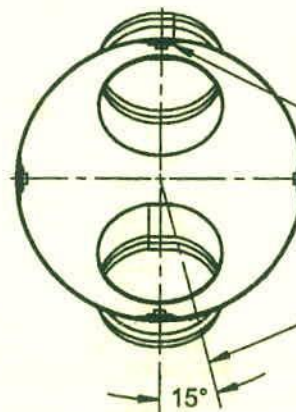
Job Completion



U 06/10/17

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 2 OF 7
DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:4

LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)**SECTION A-A**D3476-1
DUCT (1)D3476-3
DOME (1)D3476-7 TUBE
(2 PLACES)NAS-1031C3W
NUT PLATES
(4 PLACES)OFFSET SEAM
ON DUCTSHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

06-01-27 WITHOUT NOTICE

WORK ORDER

NO. 28565

**D3476-043 BLOWER MOTOR
ADAPTER WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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NO. 37

AMS-W-6858A

~~AWS D17.1.2001~~

QUALIFICATION TEST RECORD

Name Helanie FrouxJoint Welding Procedure SpotweldingPart number and Job number D3476-1 B28873 / D3476-043 B28565

TEST WELDS REQUIRED.

BASE METAL SS.WELDING PROCESS SpotweldPenetration Complete ☐ Partial ☐Single Weld ☐ Double Weld ☐Current AC ☐ DC ☒Backing YES ☐ NO ☐

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐Penetration Pass ☒ Fail ☐Crossbolt Spacer Pass ☐ Fail ☐

AMS-W-6858A

The above named individual is qualified in accordance with ~~AWS D17.1.2001~~ to weldDate of Test Coupon 06.10.17Qualifier Jan Muth

